

Date: Thursday, 4/12/2007 8:21:30 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB ASSEMBLY
Job Number	: 31651		
Estimate Number	: 10194		
P.O. Number	: <i>N/A</i>	Part Number	: D2174041
This Issue	: 4/12/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2174 REV E
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 30808	Drawing Revision	: E
		Material	: <i>N/A</i>
Written By	:	Due Date	: 4/30/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	:		<i>33</i>
	: Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM		
	: Est Rev: E As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D21741	Web
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	<i>B31689 x 33mx -</i>

2.0	D21751	Angle LH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	<i>B30871 x 4mx, B31690 x 29mx -</i>

3.0	D21752	Angle RH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	<i>B31441 x 18mx, B31691 x 15mx -</i>

4.0	MS20470AD46	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 19.0000 Each(s)/Unit Total : 760.0000 Each(s)
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	<i>m103691 -</i>

MF 07-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 31651

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1:



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per Dwg D2174-041
2- Identify as D2174-041

MF 07-05-28

(32)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/30

(33)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103141

BR/FEL. 07-05-31

(33)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF 07-06-05

9.0 AN526C832R14 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Screw
Batch: M9216

10.0 AN960JD8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Washer
Batch: M103585¹²⁵

(35)

M104093

11.0 MS21042L08 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Nut
Batch: M104118

2/2/1 SA

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install nuts & bolts loosely as per Dwg D2274

MF 07-06-05

(33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 31651

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/05 (33)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (33)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(33)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

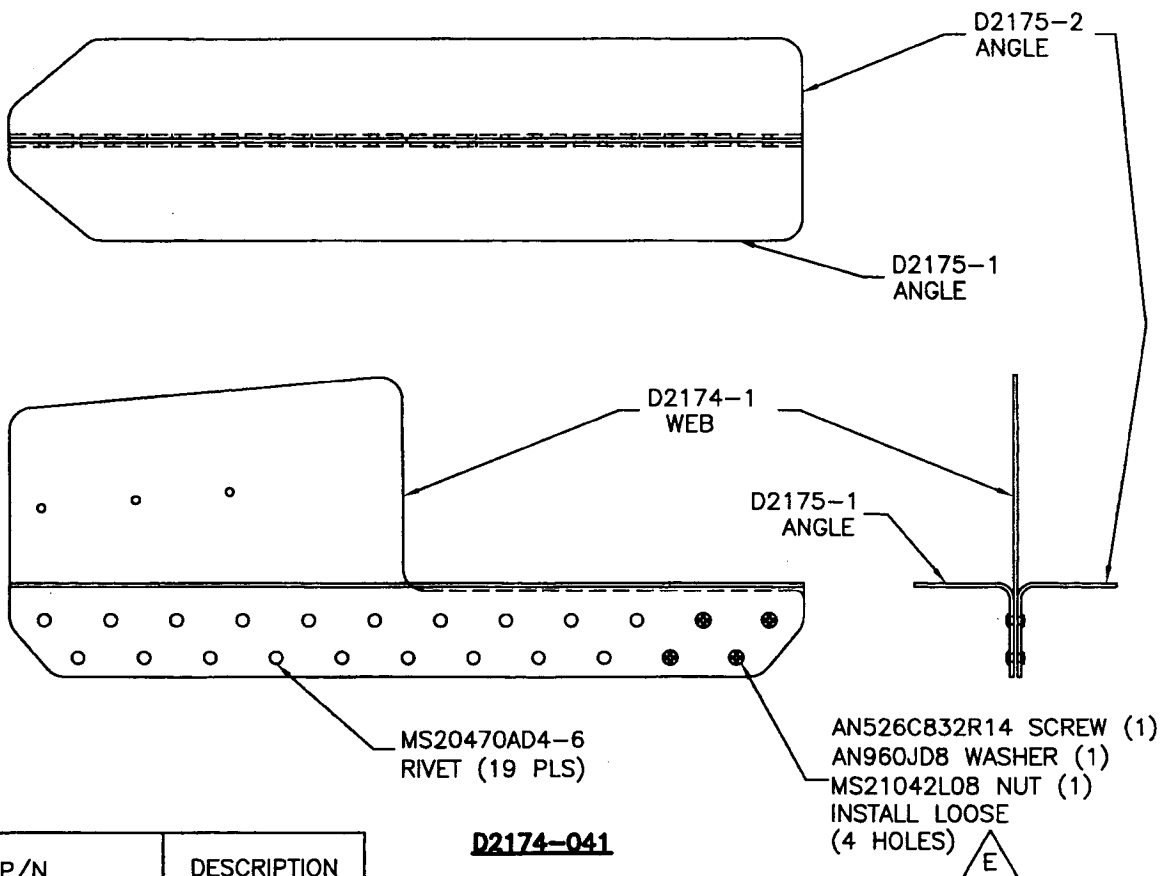
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	CE	DART Aerospace LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	CH	DRAWING NO. D2174
DATE	06.09.25	TITLE	WEB ASSEMBLY	REV. E
				SHEET 1 OF 2
				SCALE 1:3
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE		



D2174-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3651

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

